

Work Order ID 67563

Monday, March 28, 2011 11:07:33 AM

*Ship
1st April*

Page 1

Item ID: D4038-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Fwd, RH

Start Date: 3/28/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *UMF*Date: *11-03-28*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4038

D

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank 7.125" long

*enl 11/03/29**3**0*

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg & Folio FA880

Dwg Rev: *11/03/29*Folio Rev: *11/03/30*

Deburr

*enl 11/03/30**3**0*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

anh 11/03/30

3

/

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

J 11/3/30

3

/

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

3 BK 11-3-30

Hand Finishing

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Required Date: 4/5/2011 Req'd Qty: 3.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

3 4 11/07/31

160



Packaging

Packaging

Identify as per dwg & Stock Location 112

0.00

Memo

0.00

11/3/31 32

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/31

mf
11-03-31

W/O:		WORK ORDER CHANGES						
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Picklist Print

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Page 1

Work Order ID: 67563



Parent Item: D4038-2



Parent Item Name: Angle, Fwd, RH



Start Date: 3/28/2011

Required Date: 4/5/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250 		Purchased	No			100	f	0.0000	0.7	2.210526			
6061T6 ANGLE 4.00 x 4.00 x .250													

M114 507 2.21" enr 11/03/29

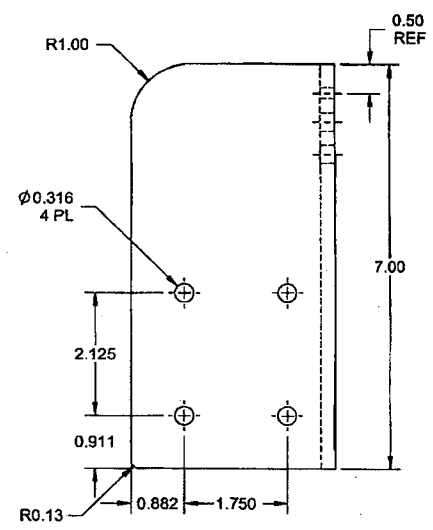
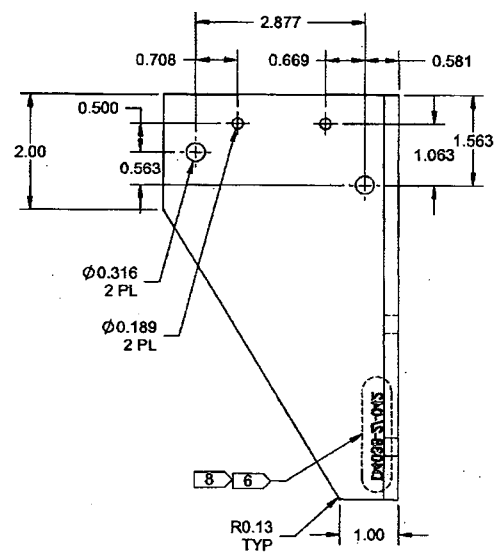
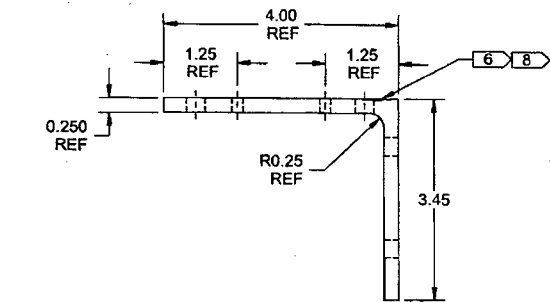
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67563

RELEASED
2011-03-16

D4038-2 ANGLE, FWD, RH

- NOTES:**
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
 - 7) WEIGHT: 1.04 lbs
 - 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4038	SHEET 4 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.03.03	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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